Monday, 6/5/2006 11:01:41 AM Kim Johnston Process-Sheet Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : LUG Job Number : 27417 : 10271 **Estimate Number** : NIA : D2561 P.O. Number Part Number This Issue : 6/5/2006 S.O. No. : NA **Drawing Number** : D2561 REV B : NC : N/A Prsht Rev. Project Number : NA : MACHINED PARTS : B First Issue Type **Drawing Revision** : 25968 **Previous Run** Material : N/A **Due Date** : 6/26/2006 Qty: 30 Um: Each Written By Checked & Approved By 00.05.19 Added inspect level 8 EC Comment : Est **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** M6061T6B0250X06000 6061-T6 Bar .25" x 6.0" 1.0 Comment: Qty.: 0.3850 f(s)/Unit Total: 11.5511 f(s) Material:6061-T6, or 5052-H34 6.00" x 0.25" Thick m17869 Batch: 1100782 2+4 BAND SAW BAND SAW Comment: BAND SA -Cut blanks: 8.70" Note: 1 blank makes 2 parts Ma 06 07 (30) Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2561 2-Deburr, no sharp edges 4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
					L		

NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			
 	T	Description of NC		Corrective Action Section B		Verification	Annaval	
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category: NCR:	Yes No DQA:	Date: <u>06/06/15</u>
NOTE: Date & initial all entries	~	Q.	QA: N/C Closed:	Date:

Monday, 6/5/2006 11:01:41 AM Date: Use?: Kim Johnston **Process Sheet Drawing Name: LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27417 Part Number: D2561 Job Number: Seq. #: **Machine Or Operation:** Description: 5.0 QC8 SECOND CHECK 30 Comment: SECOND CHECK SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 30 Deburr, no sharp edges 06106111 PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 DC W 06/06/13 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion please drill .257 boles before deburing

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
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NCR:		WORK ORDER NON-CONF	ORMANCE (NC	R)							

NCR:		,	WORK ORD	ER NON-CONFORMAN	CE (NCR)								
		Description of NC		Corrective Action Section B		Verification		Annewal					
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector					
				,									

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	1/C C	losed:	Date:

DART AEROSPACE LTD	Work Order:	27417
Description: Lug Plate	Part Number:	D2561
Inspection Dwg: D2561 Rev: B		Page 1 of 1

	X	First Arti	cle _	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.500	V		vern	
2. § 25	+/-0.010	2.525	V		vern	
3.975	+/-0.010	3.981	V,		Vern	
Ø0.257	+0.005/-0.000	0,260			Vern	
4.525	+/-0.010	4.520	1		Vern	
5.025	+/-0.010	5.034	/		vern	
0.25	+/-0.030	O. 248			Jem	
		-				
	3					
						
asured by:	M.M	Audited by:	12		Prototype App	roval: N/A
Date:	06 06 07	Date:	0606.0	6	2	Date: JA



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,	CANADA		
CHECKED	APPROVED	DRAWING NO.		REV.	. 8
Bul	BW	D2561	SHEET		F 1
DATE	<u> </u>	TILE .		SC	ALE:
96.04.26		LUG PLATE			1:1

